

20-7918



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D2435**Job Sheet 204585****Part No:** D2435**Job Qty:** 12 pcs **DAS****Part Name:** Bearpaw**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/13/19**Job Tracking No:****Due Date:** 1/29/20**Created By:** Jennifer Renwick**Type:** Stock**Description:****Note:** DWG REV E1**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Omax - 1	12 pcs	1/29/20	1/29/20	0.17	2.00	Waterjet - Omax	DAS	20/01/03
130	HAAS 4 Axis - B4B	12 pcs	1/29/20	1/29/20	1.00	12.17	HAAS - 1 - B4B	52	20/01/18
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
150	QC 8	12 pcs	1/29/20	1/29/20	0.00	0.00	QC 8 - 12		20/01/18
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		

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				QC 8 - 61				
151	Packaging 3-1 - Stock - B4B 12 pcs	1/29/20	0.00	0.00	Packaging 3 - 1 - B4B			
					Packaging 3 - 2 - B4B			
					Packaging 3 - 3 - B4B			
					Packaging 3 - 4 - B4B			
					Packaging 3 - 5 - B4B	DAS		
					Packaging 3 - 6 - B4B	28		
					Packaging 3 - 7 - B4B	9-89		
					Packaging 3 - 8 - B4B			
					Packaging 3 - 9 - B4B			
					Packaging 3 - 10 - B4B			
					Packaging 3 - 11 - B4B			
					Packaging 3 - 12 - B4B			
					Packaging 3 - 13 - B4B			
					Packaging 3 - 14 - B4B			
					Packaging 3 - 15 - B4B			
					Packaging 3 - 16 - B4B			
					Packaging 3 - 17 - B4B			
					Packaging 3 - 18 - B4B			
					Packaging 3 - 19 - B4B			
					Packaging 3 - 20 - B4B			
					Packaging 3 - 21 - B4B			
					Packaging 3 - 22 - B4B			
					Packaging 3 - 23 - B4B			
					Packaging 3 - 24 - B4B			
					Packaging 3 - 25 - B4B			
					Packaging 3 - 26 - B4B			
					Packaging 3 - 27 - B4B			
					Packaging 3 - 28 - B4B			
					Packaging 3 - 29 - B4B			
					Packaging 3 - 30 - B4B			
					Packaging 3 - 31 - B4B			
					Packaging 3 - 32 - B4B			
					Packaging 3 - 33 - B4B			
					Packaging 3 - 34 - B4B			
					Packaging 3 - 35 - B4B			
					Packaging 3 - 36 - B4B			
190	QC 21 - SA	12 pcs	1/29/20	0.00	0.00	QC 21 - SA - 21		
						QC 21 - SA - 70	DAS	JAN 24 2020
						QC 21 - SA - 53	21	
Part Op 120 - Waterjet 2 OMAX (Waterjet 2) CUT BLANK AS PER FILE D2435 Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435 150 - (QC8- Inspect parts - second check) 151 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)								
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	38.4000 sf (3.2 ea)	120-Waterjet - Omax - 1		5228711 5154152 5235828			
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
120-Waterjet - Omax - 1	MUHMWB10	38	669	0				

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053	0.059	
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	45	Angle
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470	5.500	
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170	0.200	
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	.25	Radius
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220	.25 RAD.	
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595	0.64	
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.25	
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45°	Angle
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365	0.385	
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	19.00	
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	0.960	
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	.26	Diameter
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	.930	Diameter
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	.325	
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	0.375	
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	7.375	
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	4.250	
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	2.000	
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	9.000	
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	15.750	

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Entered: 7/8Date: Feb 12/2020NCR No. 20-7918

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>904585</u> Part No. <u>D2435</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐						
Date: <u>20/01/18</u>	Sequence #: <u>130</u>	QTY Affected: <u>1</u>		MRB (QSI042) DAS 9 9-89 <u>20-01-21</u>				
Description Work Order Deviation Deep g scratch in beanpaw caused by tool		Disposition Scrap		Completed By <u>SC.</u> <u>20/01/18</u> Lead hand / Supervisor <u>ank</u> <u>20/01/18</u> QC / QA Coordinator DAS 9 9-89 <u>20-01-21</u>				
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:33%; vertical-align: top;"> ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled </td> <td style="width:33%; vertical-align: top;"> ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function </td> <td style="width:33%; vertical-align: top;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up </td> <td style="width:33%; vertical-align: top;"> ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread </td> </tr> </table> Other/Details:			☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
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